

# Work Order ID 69026

Wednesday, April 27, 2011 10:57:27 AM



Page 1

Item ID:	D3201-4	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	4/27/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	5/3/2011	Req'd Qty:	12.00		Customer:	

Reference:

Approvals:	Process Plan:		Date:	11-04-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3201	Rev B								
100		0.00							
	FLOW WATER JET								
Waterjet	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3201								
7674 .050	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	<b>Memo</b>	0.00							
Quality Control									

1B11-5-4

20

1B11-5-4

8/10/104

count  
21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69026

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Item ID: D3201-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr Stack								
140		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Bend as per Dwg D3201								
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

N/A

SB 11/6/05

SB 11/6/05

counts  
(21)

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 69026

Wednesday, April 27, 2011 10:57:27 AM



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Item ID: D3201-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x21  $\phi$  20 u/05/05

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 7 m-h 11/05/05 (21x)

180

Identify as per dwg & Stock Location: 41

0.00



Packaging

Memo

0.00

Packaging

11/5/10 sf 211

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 69026**

Wednesday, April 27, 2011 10:57:27 AM

Page 4

Item ID: D3201-4

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Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 4/27/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11

11-05-6  
21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, April 27, 2011 10:57:34 AM

Page 1

Work Order ID: 69026



Parent Item: D3201-4



Parent Item Name: Doubler



Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: A Removed from 9 Digit 06-01-25 JLM  
IPP Rev:B Now on Waterjet 06-08-14 JLM  
IPP Rev :C Added scribing, NCR262 07.11.29 EC IPP Rev:D  
10.10.29 remove scribe b# & p# DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 		Purchased	No			100	sf	18.6488	0.045	0.568421	1.		
2024-T3 .050 sheet											1811-5-4		

Location

Loc Qty

Loc Code

MAT22

18.648842

114968

18.648842

114968

21

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ - \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES						
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

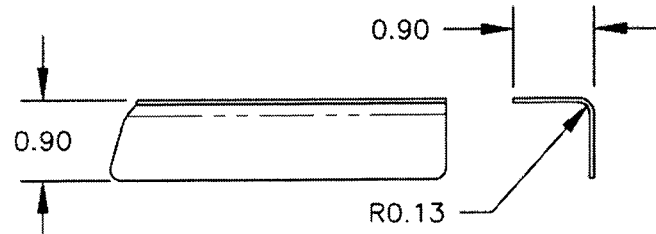
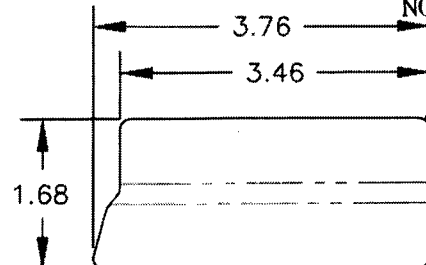
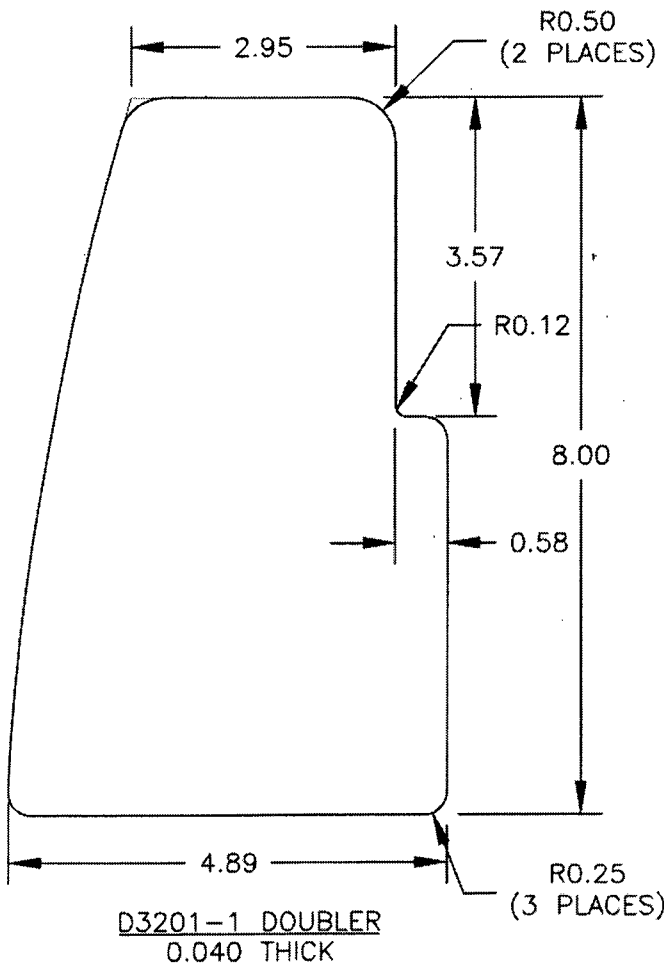
RELEASED  
03.11.04 *[Signature]*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. *69024*

R0.12  
(TYP)

GRAIN  
DIRECTION



#### D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)  
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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